

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015919**Date Inspected:** 27-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

OBG Seg 11CE (Green Tag DCP):

This QA Inspector, along with Mr. Math Manjunath; performed Green Tag DCP for OBG Seg 11CE from Panel Point (PP) 101 to PP103.5.

The details are as mentioned below:

- Dimension measurements of:

1) Corner assembly cope holes at PP101, PP101.5, PP102, PP102.5, PP103 & PP103.5 [at both Cross Beam (CB) side and Bike Path (BP) side].

2) Floor Beam to Bottom Panel cope holes & Floor Beam to Longitudinal Diaphragm cope holes at PP101, PP102 and PP103.

- Plumbness and flatness measurement of Deck Panel (DP) to DP diaphragm at PP101, PP102 and PP103.

- Floor beam flatness at PP101, PP102 and PP103 (at both CB side and BP side).

- Skin flatness of Side Panel (SP) to Corner assembly from PP101 to PP103.5 (at both; CB side and BP side)

The measured readings were noted on Dimension Control Forms and are submitted to the Task Leader for review.

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

WELDING INSPECTION REPORT

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The Flux Cored Arc Welding (FCAW) process on weld joint no: BK001-043-007. The welder was identified as 220066 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-TC-U4c-F. See attached photo for further details.

Cross Beam 12:

The FCAW process on weld joint no's: SP206-012-050, 052, 054 and 056. The welder was identified as 222396 and was observed welding in the 2F position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no's: FB203-012-013, 015 and 017. The welder was identified as 217185 and was observed welding in the 2F position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh
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Quality Assurance Inspector

Reviewed By:	Peterson,Art
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QA Reviewer
